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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W6
Job Sheet 185207



7314
Dec 7

Part No: RBE105-14181W6

Job Qty: 1 ea

Part Name: Flange Bushing Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W6 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

733

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs		11/16/18	0.00	1.00	Small Fab-4		Michel DAS
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-1		MLC 9-89
140	QC21-FG	1 Ea		11/16/18	0.00	0.00	QC21		DEC 12 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1170-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5113449
APP-1170-E	Case	1 Ea (1 ea)	90-Start up Operation	50223009
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
RBE105-14181W6-11	Top Foam	1 (1 ea)	90-Start up Operation	5128710
RBE105-14181W6-9	Bottom Foam	1 (1 ea)	90-Start up Operation	5128711
RBE105-14181W6-1	Plunger	1 Ea (1 ea)	110-Small Fab	5124615
RBE105-14181W6-3	Drift	1 Ea (1 ea)	110-Small Fab	5126176
RBE105-14181W6-5	Guide Bushing	1 Ea (1 ea)	110-Small Fab	5126690
RBE105-14181W6-7	Support	1 Ea (1 ea)	110-Small Fab	5123796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	795	0
	APP-1170-E	1	4	0
	RB41011	1	732	0
	RBE105-14181W6-11	1	0	0
	RBE105-14181W6-9	1	0	0
110-Small Fab	RBE105-14181W6-1	1	0	0
	RBE105-14181W6-3	1	0	0
	RBE105-14181W6-5	1	0	0
	RBE105-14181W6-7	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Part Specifications

Specifications could not be found.

Plex 10/24/18 8:26 AM Dart.lajeunesse.marie



Container No: S137219



Part: RBE105-14181W6

Job No: 185207

Serial No/Batch: S137219

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/12/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

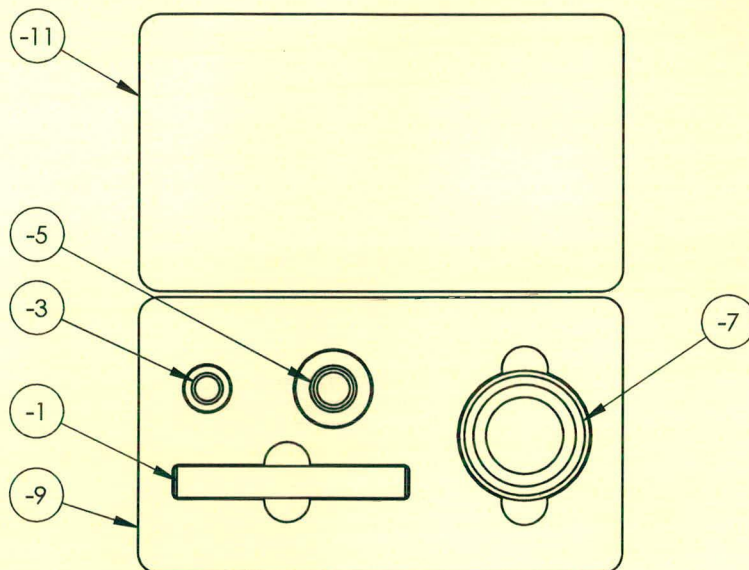
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.			5/24/2016	RJC JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185207 MC5

18-10-24

NOTE:
REF. EUROCOPTER T/N 105-14181W6.

DART AEROSPACE																													
TITLE PUSHING-OUT TOOL																													
DWG NO. RBE105-14181W6	REV 1																												
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: CLOUGH</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>3. INTERPRET DIM AND TOL PER</td> </tr> <tr> <td></td> <td>ASME Y14.5M-2009</td> </tr> <tr> <td>SCALE 1:2</td> <td>USED ON MODEL</td> </tr> <tr> <td>DATE 1/13/2016</td> <td>EC145</td> </tr> <tr> <td colspan="2">SHEET 1 OF 7</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES	CHECKED: DUERFELDT	.015 x 45° OR .015R	OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	QA APPR: LINDSAY	AFTER PLATING	APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER		ASME Y14.5M-2009	SCALE 1:2	USED ON MODEL	DATE 1/13/2016	EC145	SHEET 1 OF 7	
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DATE 1/13/2016	EC145																												
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLUNGER	A36/1018/1020 HR		2
			-3	1	DRIFT	A36/1018/1020 HR		3
			-5	1	GUIDE BUSHING	6061		4
			-7	1	SUPPORT	6061		5
		B/O	-9	1	BOTTOM FOAM	Y20 BLACK	2.08 X 6.04 X 10.54 (I.R. SPECIALTIES)	6
		B/O	-11	1	TOP FOAM	Y20 BLACK	1.08 X 6.04 X 10.54 (I.R. SPECIALTIES)	7
		B/O	-13	1	CASE	PLASTIC	PELICAN CASE #APP-1170-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

